

M8DF

8D Drill With
Coolant Holes

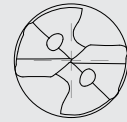
Stock	Order No	Code	d1h7	d2h6	l1	l2	l3
	73100	M8DF.2.0505.0950.A0138.0480.0000.0570.00.S06B2B02.01	5,05	6	95	48	57
	73102	M8DF.2.0520.0950.A0135.0530.0000.0590.00.S06B2A05.01	5,2	6	95	53	59
*	73104	M8DF.2.0600.0950.A0140.0530.0000.0570.00.S06B2A05.01	6	6	95	53	57
	73106	M8DF.2.0630.1140.A0140.0640.0000.0760.00.S08B2A05.01	6,3	8	114	64	76
	73108	M8DF.2.0650.1140.A0140.0640.0000.0760.00.S08B2B02.01	6,5	8	114	64	76
*	73110	M8DF.2.0680.1140.A0140.0640.0000.0760.00.S08B2A05.01	6,8	8	114	64	76
	73112	M8DF.2.0700.1140.A0135.0640.0000.0760.00.S08A2A05.01	7	8	114	64	76
	73114	M8DF.2.0750.1140.A0140.0640.0000.0760.00.S08B2A05.01	7,5	8	114	64	76
	73116	M8DF.2.0760.1140.A0140.0640.0000.0760.00.S08B2A05.01	7,6	8	114	64	76
	73118	M8DF.2.0780.1140.A0142.0640.0000.0760.00.S08B2C06.01	7,8	8	114	64	76
*	73120	M8DF.2.0800.1140.A0140.0640.0000.0760.00.S08B2L01.01	8	8	114	64	76
*	73122	M8DF.2.0850.1420.A0135.0800.0000.0950.00.S10B2A05.01	8,5	10	142	80	95
	73124	M8DF.2.0880.1420.A0140.0800.0000.0950.00.S10B2A05.01	8,8	10	142	80	95
	73126	M8DF.2.0900.1420.A0138.0800.0000.0950.00.S10B2B03.01	9	10	142	80	95
	73128	M8DF.2.0950.1420.A0140.0800.0000.0950.00.S10B2L01.01	9,5	10	142	80	95
	73130	M8DF.2.0980.1420.A0135.0800.0000.0950.00.S10B2A05.01	9,8	10	142	80	95
	73132	M8DF.2.0990.1420.A0140.0800.0000.0950.00.S10B2L01.01	9,9	10	142	80	95
*	73134	M8DF.2.1000.1420.A0135.0800.0000.0950.00.S10B2B03.01	10	10	142	80	95
*	73136	M8DF.2.1020.1620.A0138.0960.0000.1140.00.S12B2L01.01	10,2	12	162	96	114
*	73138	M8DF.2.1050.1620.A0135.0960.0000.1140.00.S12B2B03.01	10,5	12	162	96	114
	73140	M8DF.2.1100.1620.A0140.0960.0000.1140.00.S12B2B03.01	11	12	162	96	114
	73142	M8DF.2.1180.1620.A0135.0960.0000.1140.00.S12B2A05.01	11,8	12	162	96	114
*	73144	M8DF.2.1200.1620.A0135.0960.0000.1140.00.S12B2B03.01	12	12	162	96	114
*	73146	M8DF.2.1250.1780.A0140.1120.0000.1310.00.S14B2C06.01	12,5	14	178	112	131
	73148	M8DF.2.1270.1780.A0140.1120.0000.1310.00.S14B2C06.01	12,7	14	178	112	131
	73150	M8DF.2.1300.1780.A0140.1120.0000.1310.00.S14B2B03.01	13	14	178	112	131
	73152	M8DF.2.1400.1780.A0135.1120.0000.1310.00.S14B2A05.01	14	14	178	112	131
	73154	M8DF.2.1450.2030.A0135.1280.0000.1520.00.S16B2A05.01	14,5	16	203	128	152
	73156	M8DF.2.1500.2030.A0135.1280.0000.1520.00.S16B2A05.01	15	16	203	128	152
	73158	M8DF.2.1550.2030.A0135.1280.0000.1520.00.S16B2A05.01	15,5	16	203	128	152
	73160	M8DF.2.1580.2030.A0135.1280.0000.1520.00.S16B2A05.01	15,8	16	203	128	152
	73162	M8DF.2.1600.2030.A0135.1280.0000.1520.00.S16B2A05.01	16	16	203	128	152
	73164	M8DF.2.1650.2220.A0135.1440.0000.1710.00.S18B2A05.01	16,5	18	222	144	171
	73166	M8DF.2.1700.2220.A0140.1440.0000.1710.00.S18B2C06.01	17	18	222	144	171
	73168	M8DF.2.1750.2220.A0140.1440.0000.1710.00.S18B2C06.01	17,5	18	222	144	171
	73170	M8DF.2.1800.2220.A0140.1440.0000.1710.00.S18B2C06.01	18	18	222	144	171
	73172	M8DF.2.1850.2430.A0140.1600.0000.1900.00.S20B2C06.01	18,5	20	243	160	190
	73174	M8DF.2.1900.2430.A0140.1600.0000.1900.00.S20B2C06.01	19	20	243	160	190
	73176	M8DF.2.1950.2430.A0140.1600.0000.1900.00.S20B2C06.01	19,5	20	243	160	190
	73178	M8DF.2.2000.2430.A0140.1600.0000.1900.00.S20B2C06.01	20	20	243	160	190

Cutting Parameters Vc(m/min)			Feed Per Revolution (mm/rev)	
Non-Alloy Steel	80-105	●	0	
Steel	70-100	●	3	0,112
Tempered Steel	70-95	●	4	0,119
Cold-Work Tool Steel	50-80	●	5	0,126
Hot-Work Tool Steel	50-80	●	6	0,140
AISI 304 - 416 - 420	50-55	○	7	0,154
AISI 316 - 440	50-55	○	8	0,168
17-4 PH 15-5 PH	40-50	○	9	0,189
Chrome-Cobalt Alloy	40-50	○	10	0,210
Duplex F51	30-40	○	12	0,231
Super Duplex F55	30-40	○	14	0,252
Grey Cast Iron	140-170	●	16	0,273
Alloy Cast Iron	110-140	●	18	0,294
Precision Cast	80-110	●	20	0,315
Titanium	50-70	○		
Titanium Alloys	40-60	○		
≤ 54 HRC	60-80	○		
> 54 HRC	40-55	○		



● Recommended ○ Acceptable ○ Not Recommended

*Marked products are available
from stock to deliver fast.



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